

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025198**Date Inspected:** 04-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Visual Inspection after Blast

OBG Segment 14W

This QA Inspector performed a preliminary random visual inspection on OBG Segment 14W, after the grit blast of the interior components of the longitudinal diaphragm, floor beams and bottom plate at panel point 126 to 128.3 middle location of OBG Segment 14W. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Visual inspection after the blasting: During random Quality Assurance Visual review of welds located on OBG Segment 14W, this Quality Assurance Inspector (QA) observed following details:

- At PP128.3 (W) near SEG3020D-233, 237 welds, two locations base metal deep gouge was visibly observed on the Bottom Plate (BP3091A) to Floor Beam (FB3343A).
- At PP127.5 (W) near SEG3020H-045 weld, three(3) porosity observed on Longitudinal Diaphragm (LD30050A) to Floor Beam (FB3334C). Areas were taped prior to blast and paint.
- At PP127 (E)-SEG3020H-031, near to cope hole location base metal deep gouge was visibly observed on Floor

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Beam (FB3330A) to Longitudinal Diaphragm (LD3051A).

- In between PP127.5 to 127, base metal deep gouge was visibly observed on Bottom Plate (BP3092A). Areas were taped prior to blast and paint.

- At PP127 (W) near SEG3020L-094 weld, base metal deep gouge was visibly observed on Bottom Plate (BP3091A)

- At PP127 (W) near SEG3020L-106 weld, base metal deep gouge was visibly observed on SA8502A.

Visual Inspection after Blast

OBG Segment 13AE

This QA Inspector performed a random visual inspection on OBG Segment 13AE, after the grit blast and preliminary of the interior components of the edge Plate, Anchor Plate, longitudinal diaphragm, floor beams and side plate cross beam side and cable side of OBG Segment 13AE. Areas of visual weld defects that will require welding were inform to ZPMC QC personnel. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
